Work Orde Tuesday, Decem				*94	277*	5	3h	AP =	186	2 100	Page 1
Item ID: Revision ID: Item Name:	D350-636-0 Wearshoe	043		Accept	*N900	040	100) * s	Setup Star - Stop	I NI	S1* S2*
Start Date: Required Date: Reference:	12/4/2012 12/4/2012	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:						
Approvals:		an: MF	Date: <u>/</u> /2-/2-04 Date:	Tooling: SPC (Y/N):		ate:		F	tun Star Stop	" [V]	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
N/A	Rev	v F V	SP						1.4	1517	12-04
100 *1 \\ DC Document Control		DOCUMENT CONTRO		0.00 0.00 13 obels per PPPD350-63	15 7 15 7 10 05 16-043 CHG001						12/18 0AS 20 20
*110 *110* Packaging Packaging		Pick Kit Memo	•	0.00		.*		ZX		10	\$\$ \$\rightarrow\dots\dots\dots\dots\dots\dots\dots\dots
115 *115* QC		QC4- 100% Inspect kits	for completeness	0.00 15 0.00 12 15	S 1005	•					

Quality Control

NCR:	Yes / No	WORK ORDER NON-CONFOR

DQA:	Date:	

NCR:	Yes / No				WORK ORDER NON-	CON	FORI	MANCE / UPI	DATE	QA Closed:	Date			
Work Orde	er:				DISPOSITION				AGAINST DE					
Part N					Rework Skid-tube Crosstube Scrap Machining Small Fak Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Prod. Eng. Coor. Quality Rec/Store/Packaging Other				
Root				Descri	ption of work order update	ln	itial	Act	ion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Descr	iption	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved														
						AULT	CATE	GORY						
Landir	ng Gear Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning Se	Crimped, t n Strip in Bend laves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		nstruct Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/U nance led	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Wave/Tw		e		Folio	-	Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Tuesday, Decem						,		Page 2					
ftem ID: Revision ID: Item Name:	D350-636-0	043		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	12/4/2012 12/4/2012	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:							
Approvals: Process Plan: QC:		Date:	Tooling: SPC (Y/N):	Date:Date:				Run	Start Stop	*N *N	R1* R2*		
Sequence ID/ Work Center II 120 *120* Packaging Packaging		Operation Description Packaging Memo Identify and Location: PPP Rev:	pack for shipping as per	Set Up/ Run Hours 0.00 0.00 PPP D350-636-043	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	

130

130

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MUS 12-12-05

NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
	_	

										QA Closed:	Dat	e:	
Work Orde	·r·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	0				Rework Scrap Use-as-is Work Order Update		l Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	b Prod. Eng. Coor. Qualing Rec/Store/Packaging Oth			
Root				Descr	iption of work order update	Ini	tial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	j.	f Eng		ription	Date	Verification	QC Inspector	
Doc/Data												·	
quip/Tooling	_												
Operator	7	ļ				1							
Material													
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rocess													
Supplier													
Training -							İ			,	~		
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····		•				FAULT	CATE	GORY		•			
Landin	g Gear				General						_		
	Bending				Bend	G	rain			Ovalized		Pressure/Forced	
	Centre No	ot Conce	ntric to (o/s 🗀	BOM/Route	Н	ardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorred	et [Weld	
	Crushed/	Crimped.			Burrs	In	structi	ons Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	\square	lainte	nance		Part Moved	_		
	Heat Trea	it			Countersink	Шм	1 islabe	led		Positioned V	Vrong _		
Γ	Inspection	n Strip in	Tube		Cut Too Short	Шм	lisread			Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes		ffset						
	Torque W	/aves in E	xtrusion	າ [Drawing	o	ut of C	alibration					
	Turning S	equence			Finish	o	ut of S	equence					
• [Wave/Tw	ist in Tub	e		Folio	0	utside	Dimensions					

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Location		Loc Qty	Loc Code	
FG		10		<u></u>
	122141	10		
FP001		21		
	122800	21		=
ST351		75		
	123900	75		- XX

Page 1

Status

												DQA:	Date:	:
NCR:	Yes	/ No					WORK ORDER NON-C	COI	NFORI	MANCE / UP	DATE		_	
						_	W • • · · · ·					QA Closed:	Date	:
Nork Ord	ler:					l	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	No.						Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.						Work Order Update			Large Fab	Composite	J	Supplier	
Root Cause		Date	Step	Qty	Desc	•	tion of work order update		Initial nief Eng	1	tion cription	Sign & Date	Verification	QC Inspector
oc/Data perator laterial etup ther cocess upplier laining							,							
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		Bending Centre No Cracks	ot Concer	ntric to (o/s	IJ₽	Bend BOM/Route Broken/Damaged		Grain Hardwa Inspecti	re on Incomplete		Ovalized Over/Under Part Incorred		Pressure/Forced Temperature/Cure Weld
		Crushed/0 Cuffs	Crimped.		F		Burrs Contamination		1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Heat Trea	-	Tube	-]	Countersink Cut Too Short		Mislabe Misread	led		Positioned V		Other
2000	-	Ripples in	Bend			<u> </u> [Drill Holes		Offset	•	L			
		Torque W Turning Se		xtrusion	` -	_	Drawing iinish		ł	Calibration Sequence				

Outside Dimensions

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Wave/Twist in Tube

Folio

Tuesday, December 04, 2012 2:02:48 PM Work Order ID: 94277 *Parent Item: D350-636-043 **Start Date: 12/4/2012 Required Date: 12/4/2012** Parent Item Name: Wearshoe Start Qty: 2.00 Required Qty: 2.00 AN960G10L NAS1149C0332R 110 Purchased No Each 21.0000 washer Location Loc Oty Loc Code ST245 21 107534 21 D3535-13 110 No Each 18.0000 Manufactured Wearshoe Location Loc Qty Loc Code FG 2 2 Sm= 27 86229 FP002 16 79850 86229-2 92344 13 No 110 Each 33.0000 Manufactured Wearshoe Loc Qty Location Loc Code FP002 33 62233 81357 87385 90061 91893 15 93278 13 .D3535:35 110 Manufactured No Each 20.0000 Loc Code

 Loc Oty
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 FP002
 20

 67598
 1

 70815
 1

 79849
 1

 86191
 1

 90092
 3

 92343
 13

D) 0-10

											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-	CONF	ORN	MANCE / UPDAT	ΓE	0.0			
										····	QA Closed:	Date:		
Work Ord	er:					DISPOSITION			,	AGAINST DE	PARTMENT/	PROCESS		
Part						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Small Fab	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR	No.					Work Order Update Large Fab Comp				omposite		Supplier		
Root					Descri	ption of work order update	Ini	tial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chie	f Eng	Description	on	Date	Verification	QC Inspector	
oc/Data						<u>.</u>								
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Landi	ng (Gear				General				<u> </u>	_			
		Bending				Bend	∐ Gi	rain			Ovalized		Pressure/Forced	
	L	Centre No	t Concer	itric to (o/s	BOM/Route	На	ardwai	re ·		Over/Under	tolerance	Temperature/Cure	
	L	Cracks				Broken/Damaged	L In:	spection	on Incomplete		Part Incorrec	t	Weld	
		Crushed/0	Crimped.			Burrs	ln	structi	ons Incomplete/Uncle	ear	Part Lost/Missing		Wrong Stock Pulled	
	Cuffs					Contamination	Шм	lainte	nance		Part Moved			
	Heat Treat					Countersink	М	islabel	ed		Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

'Picklist Print

Tuesday, December 04, 2012 2:02:48 PM

Page 3

Work Order ID: Parent Item: Parent Item Name:	94277 D350-636-043 Wearshoe								rt Date: 12/4/2012	2	Required Date: 12 Required Qty: 2.0	
D3536-13 Gasket		Manufactured	No			110	Each	23.0000	0	2	3876A	989
				Locati	<u>on</u>	Loc Oty		Loc Code				•
~~	243			FG		2	!					
					81344	2	!					
				FP001		21						^
					89686	21			42	<u> </u>		(),
D3536-25 Gasket		Manufactured	No			110	Each	15.0000	1	2	S	5
				Locati	o <u>n</u>	Loc Qty		Loc Code	Construction and the second of			
				FG		2					,	
5 6	~~				87053	2		•				
SMS	2/			FP001		13						
					83900	1						
					89057	1						·A
					91814 93154	3			<u></u>	\leftarrow		7
03536-35		Manufactured	No		93134	110	Each	24.0000				
Gasket								1			2012-12	<u>-y,</u>
				Location	<u>)n</u>	Loc Qty		Loc Code				•
SM	2~			FG		2						
عرب را	27				89650	2						
				FP001		22						
					82065	2						•
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					90843	. 6			9	<u>×</u>		
					90844	13						

NCR:	Yes	1	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:		
QA Closed:	Date:		
ARTMENT/PRO	OCESS		
	Vater Jet ng. Coor.	Engineering Quality	$\exists \mid$
Rec/Store/P		Other	

Work Order	. .				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	o				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	L ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data			,		···				'			
Equip/Tooling		·		•						1		
Operator												
Material												
Setup												
Other	_											
Process	_											
Supplier	_											
Training	_											
Unapproved		l										
						AUL	T CATE	GORY				
Landing					General					1	Г	¬
-	Bending				Bend		Grain			Ovalized		Pressure/Forced
<u> </u>	Centre No	ot Concer	itric to ()/\$	BOM/Route	\vdash	Hardwa			Over/Under		Temperature/Cure
<u> </u>	Cracks	~rimmad		-	Broken/Damaged			on Incomplete	l Incloar	Part Incorre	 	Weld
	Crushed/0	impea.			Burrs Contamination	-	Mainte	ions Incomplete/	Unclear	Part Lost/M Part Moved	_	Wrong Stock Pulled
-	Heat Trea	+			Countersink	\vdash	Mislabe		<u> </u>	Positioned V		
-	Inspection		Tuba	-	Cut Too Short	-	Misreac		-	Positioned v	_	Other
_	Ripples in		iuse		Drill Holes	\vdash	Offset	ı	<u> </u>	Trower ross/	Juige	Tottlei
<u> </u>	Torque W		xtrusion	·	Drawing	\vdash		Calibration				
-	Turning Se		43101	·	Finish			equence				
. -	Wave/Tw		e	-	Folio	-		Dimensions				
	111070711		-		1. ==		J 4 1314C					

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•	C.L		T.	ν r	11	•
	(C)	dis	L		111	L

Tuesday, December 04, 2012 2:02:48 PM

Page 4

Work Order ID:

94277

Parent Item:

D350-636-043

Parent Item Name:

Wearshoe

D3537-1

Wearpad

Manufactured

110

Each

53.0000

Start Date: 12/4/2012

Start Qty: 2.00

Required Date: 12/4/2012

Required Qty: 2.00

Location	Loc Oty	Loc Code	
FP001	53		
83254	1		
83255	3		
87697	1		
88562	9		
91645	15		/OX
91668	24		

DQA:	Date:	
	-	

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

											QA Closed.	Date	•
Work Orde	er:					DISPOSITION 4				AGAINST D	EPARTMENT	/PROCESS	
Part N	Part No. NCR No.			Rework Scrap Use-as-is Work Order Update		Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update	Ī	nitial	Ad	ction	Sign &		
Cause	Da	te S	tep	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling													
Operator	_						1						
Material													
Setup	_								١				
Other	_												
Process	4												
Supplier	_												
Training													
Unapproved					<u> </u>	F	<u>Ι</u> Δ111	T CATE	SORY		<u> </u>	<u> </u>	
Landin	ng Gear					General	701	CATE	30,11				
	Bend	ing				Bend		Grain			Ovalized		Pressure/Forced
		e Not C	oncen	tric to	o/s	BOM/Route	-	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac					Broken/Damaged	-		on Incomplete		Part Incorre	<u> </u>	Weld
!	Crus	ned/Crin	nped.			Burrs	\vdash		ions Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
[Cuffs					Contamination	П	Mainte	nance		Part Moved		
	Heat	Treat				Countersink		Mislabe	led		Positioned V	Vrong	
	Inspe	ction St	rip in	Tube		Cut Too Short		Misread	l	Γ	Power Loss/	Surge	Other
	Ripp	es in Be	nd			Drill Holes		Offset					
	Torq	ie Wave	es in Ex	xtrusio	n [Drawing		Out of C	Calibration				,
	Turn	ng Sequ	ence			Finish		Out of S	equence				
	Wav	/Twist i	n Tub	e		Folio		Outside	Dimensions				
				/4100144									

NCR: Yes / No

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REFERENCE ONLY

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IIN-D350-636

Page 25 of 31

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty_ [-043]	Part Number	Description.
*20A	4	4	4	4		AN960C10L	WASHER (REPLACES AN960JD10)
*20B	4	4	4	4		NAS1515H3L	WASHER (REPLACES AN960JD10)
*22	5	5	5	5	-5 ==	-D3537-1	-WEARPAD (REPLACES D2648-3)
*23A	1	1	1	1	=	ED3535=13======	:WEARSHOE (REPLACES D2656-13)
*23B	1	1	1	1	*1	■D3536-13	GASKET
*24A	1	1	1	1	el=	:D3535-25	-WEARSHOE (REPLACES D2746)-
*24B	1	1	1	1	-1	D3536-25	FGASKET———
*25A	1	1	1	1		-D3535-35 <u></u>	:WEARSHOE (REPLACES D2656-35)
*25B	1	1	1	1	-1-	D3536-35	-GASKET
*26A	38	38	38	38	~ 38=	=AN3G5A=======	-BOLT-(REPLACES AN3-5A)
*26B	4	4	4	4		=AN3C7A=====	BOLT:(REPLACES ANS-7A)
*27	42	42	42	42	=42 =	=AN960C10L=====	-WASHER (REPLACES AN960JD10)
*28	38	38	38	38	ļ	ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER
	I	1	I	l			

^{*} PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

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Date: 10.10.25

^{**} TO BE SUPPLIED BY CUSTOMER

^{***} ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

Page 24 of 31

5.0 **PARTS LIST** (D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 003)

ltem	Qty -011	Qty -012	Qty -013	Qty -014	Qty_ 043	Part Number	Description
	x					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	· · · · · · · · · · · · · · · · · · ·	x				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			х			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				х	- 1	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-043	WEARSHOE KIT (REPLACES -041 KIT)
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		11				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT (REPLACES AN8-35A)
*6A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
*6B	2	2	2	2		NAS1515H8L	WASHER
*7	1	1	1	1		MS21083C8	NUT (REPLACES MS21083N8)
*8	1		1			D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
*8		1		1		D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT (REPLACES AN8-16A)
11A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
11B	2	2	2	2		D3672-13	WASHER
12	2	2	2	2	· ······	MS21083C8	NUT (REPLACES MS21083N8)
*13	4	4	4	4		ALS4-1032-225	INSERT
*14	4	4	4	4		AN6C44A	BOLT (REPLACES ANG-44A)
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT (REPLACES MS21042L6)
*17	8	8	8	8		D3631-1	WASHER (REPLACES NAS1515H8L)
		1	1				
*18	4	4	4	4		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*19	4	4	4	4		AN3C6A	BOLT (REPLACES AN3-6A)

(CONTINUED ON NEXT PAGE)

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